

Date: Thursday, 7/3/2008 13:18 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	GUIDE
Job Number	40222			Part Number	D35711
Estimate Number	12687			Drawing Number	D3571 REV A
P.O. Number				Project Number	N/A
This Issue	7/3/2008	S.O. No.		Drawing Revision	A
Prsh Rev.	NC			Material	
First Issue	/ /	Type	MACHINED PARTS	Due Date	7/21/2008
Previous Run	38299			Qty:	21
Written By	<u>dkj</u> 08.07.04			Um:	Each
Checked & Approved By					
Comment	Est Rev:A New Issue 07-02-01 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"	
		Comment: Qty.: 0.2531 f(s)/Unit Total : 5.3141 f(s) 6061-T6 Bar .75" X 1.5" Batch: M108118	H.A 08/07/05
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blank 2.90 " long	H.A 08/07/05
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA675Rev: AA & Dwg D3571 Rev: A	
	2-Deburr per dwg D3571		H.A/2nd 08/07/05
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	H.A/2nd 08/07/05
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	SL 08/07/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/3/2008 3:31:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: GUIDE
Job Number: 40222		Part Number: D35711
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 X22
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>ML/PL</i>		
7.0	POWDER COATING 	POWDER COATING <i>in 06492</i> (22)
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 START TIME: <u>1:30</u> <i>BL 12/12-08/07/10</i> OVEN TEMPERATURE: <u>320</u> (22) FINISH TIME: <u>200</u>		
8.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION (22)
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 (22)
Comment: PACKAGING RESOURCE #1 Identify with P/N and B/N using a permanent fine point marker, then Stock Location: <u>ST 244</u> <i>18 08/07/10 (22)</i>		
10.0	QC21 	FINAL INSPECTION/W/O RELEASE <i>08/07/10 (22)</i>
Comment: FINAL INSPECTION/W/O RELEASE Job Completion 		<i>MF 08-07-10</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40222
Description: Guide	Part Number:	D3571-1
Inspection Dwg: D3571 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>J.A./cmf</u>	Audited by:	<u>DSP</u>	Prototype Approval:	N/A
Date:	08/07/07	Date:	08/07/07	Date:	N/A

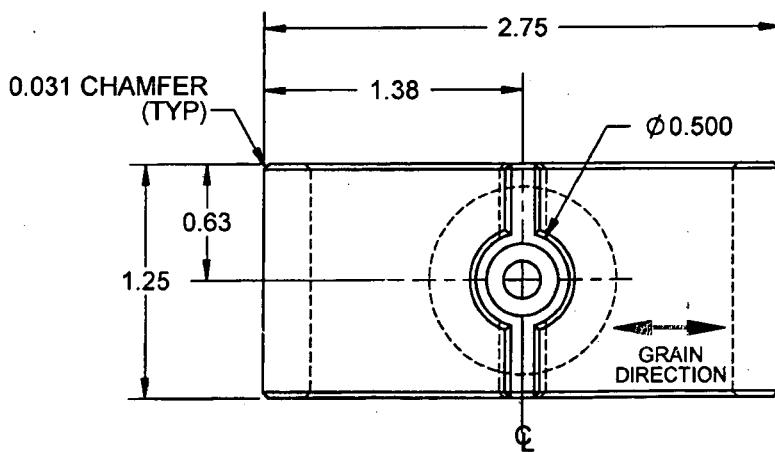
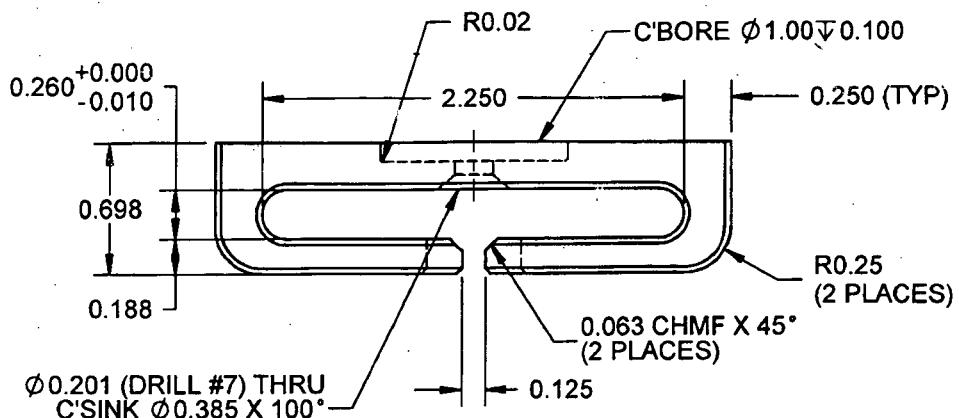
Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	JL

DART

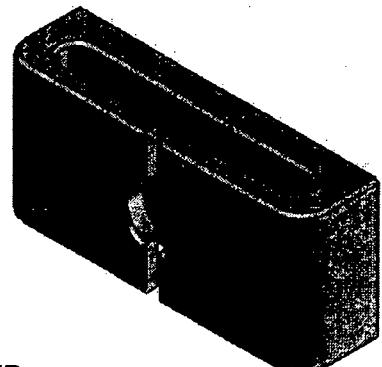
DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571
DATE 07.01.29		REV. A SHEET 1 OF 2
		SCALE 1:1
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE

RELEASED

07.04.12



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D3571-1 GUIDE**NOTES:**

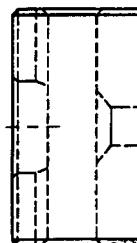
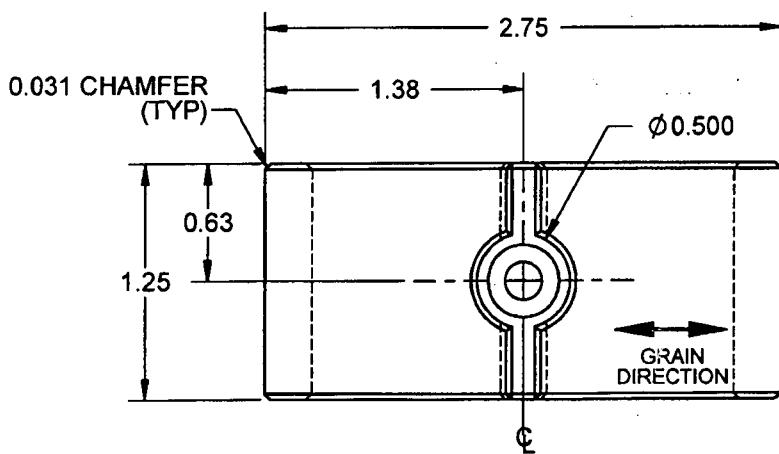
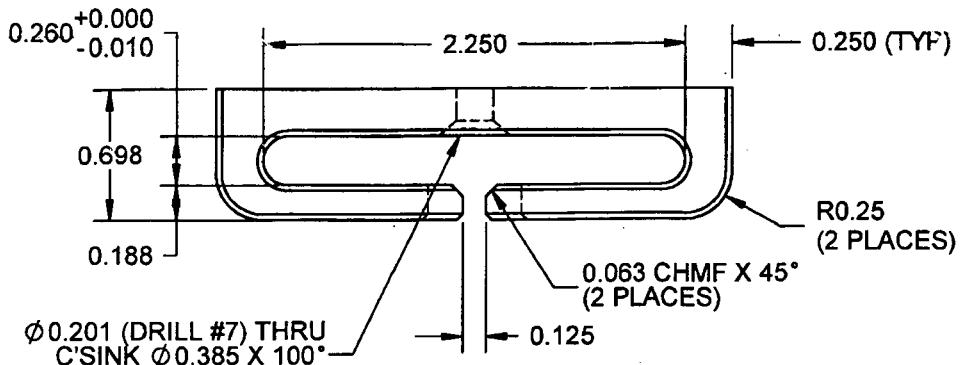
- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT $\frac{1}{2}$

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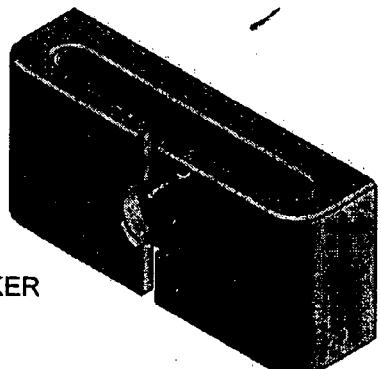
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DART

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>JM</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29	TITLE GUIDE	SCALE 1:1	

RELEASED07.01.12 *[Signature]*

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D3571-3 GUIDE**NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT 'C'

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